

# Work Order ID 80733

February-28-12 10:33:44 AM

ASAP

\*80733\*

Page 1

Item ID: D2432

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: 206 (24") Bearpaw

Start Date: 28/02/2012 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/28 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

\*120\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B12-3-3

130

0.00

\*130\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio and Dwg D2432 Identify as D2432F  
3-Deburr

PO / SL 12/03/13 (12)

140

QC2- Inspect parts off machine FAI/FAIB

0.00

\*140\*

QC

Memo

0.00

Quality Control

PO 12/03/12

SL 12/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 80733

February-28-12 10:33:44 AM

**\*80733\***

Page 2

Item ID: D2432

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Revision ID:

Item Name: 206 (24") Bearpaw

Stop

**\*NS2\***

Start Date: 28/02/2012 Start Qty: 12.00

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Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00

*aml 12/03/13*

**\*150\***

QC

Memo

0.00

Quality Control

*12 0*

151

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*151\***

Packaging

Memo

0.00

Packaging

*12/3/13*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*12/3/14*

*12-03-13*

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NOTE: Date & initial all entries

# Picklist Print

February-28-12 10:33:48 AM

Page 1

Work Order ID: 80733

\*80733\*

Parent Item: D2432

\*D2432\*

Parent Item Name: 206 (24") Bearpaw

Start Date: 28/02/2012

Required Date: 06/03/2012

Start Qty: 12.00

Required Qty: 12.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	585.1243	3.7	44.4			

\*MUHMWB10\*

UHMW 1" Black

\*\*

B12-3-3

### Location

### Loc Qty

### Loc Code

MAT018

327.48

120035

74.48

120401

253

120401

MAT019

257.6443158

117321

74.6

117738

93.8

117819

83.3

118814

1.5

119145

4.44431579

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80733
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432	<b>Rev:</b> F3	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053	✓		VERN	GA-09
B	5.500	+/-0.030	5.505	✓		VERN	GA-09
C	0.200	+/-0.030	0.195	✓			GA-08
D	0.25 x 45°	+/-0.030	0.265	✓		VERN	GA-09
E	R0.250	+/-0.030	0.250	✓		Radius gage	
F	0.250	+/-0.010	0.242	✓		MIC	118120
G	0.625	+/-0.030	0.615	✓		MIC	118120
H	0.375	+/-0.010	0.376	✓		MIC	118120
I	0.950	+0.030/0.010	0.944	✓		MIC	118120
J	19.000	+/-0.030	19.00	✓			GA-12
K	3.14	+/-0.030	3.16	✓		VERN	GA-09
L	3.28	+/-0.030	3.26	✓		VERN	GA-09
M	Ø0.260	+0.005/-0.000	0.260	✓		PIN Gage	
N	Ø0.93	+/-0.030	0.93	✓		VERN	GA-09
O	0.30	+0.030/-0.000	0.30	✓			GA-08
P	23.750	+/-0.030	23.75	✓			GA-12
Q	7.375	+/-0.030	7.384	✓			31006
R	4.250	+/-0.010	4.254	✓		VERN	GA-09
S	2.000	+/-0.030	2.02	✓			31006
T	9.000	+/-0.010	9.002	✓			31006
U	9.000	+/-0.010	9.002	✓			31006
V	0.375	+/-0.010	0.378	✓			31006

<b>Measured by:</b> PD	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/03/12	<b>Date:</b> 12/03/13	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF [Signature]	[Signature]

# Dart Aerospace Ltd

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**NOTE:** Date & initial all entries



SHOP

F1	99.03.03	ADD DEC 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 <del>RF</del>
F3	02.01.23	CLARIFY CORE DIMS <del>RF</del>

REVISIONS  
UNCONTROLLED  
SUBJECT

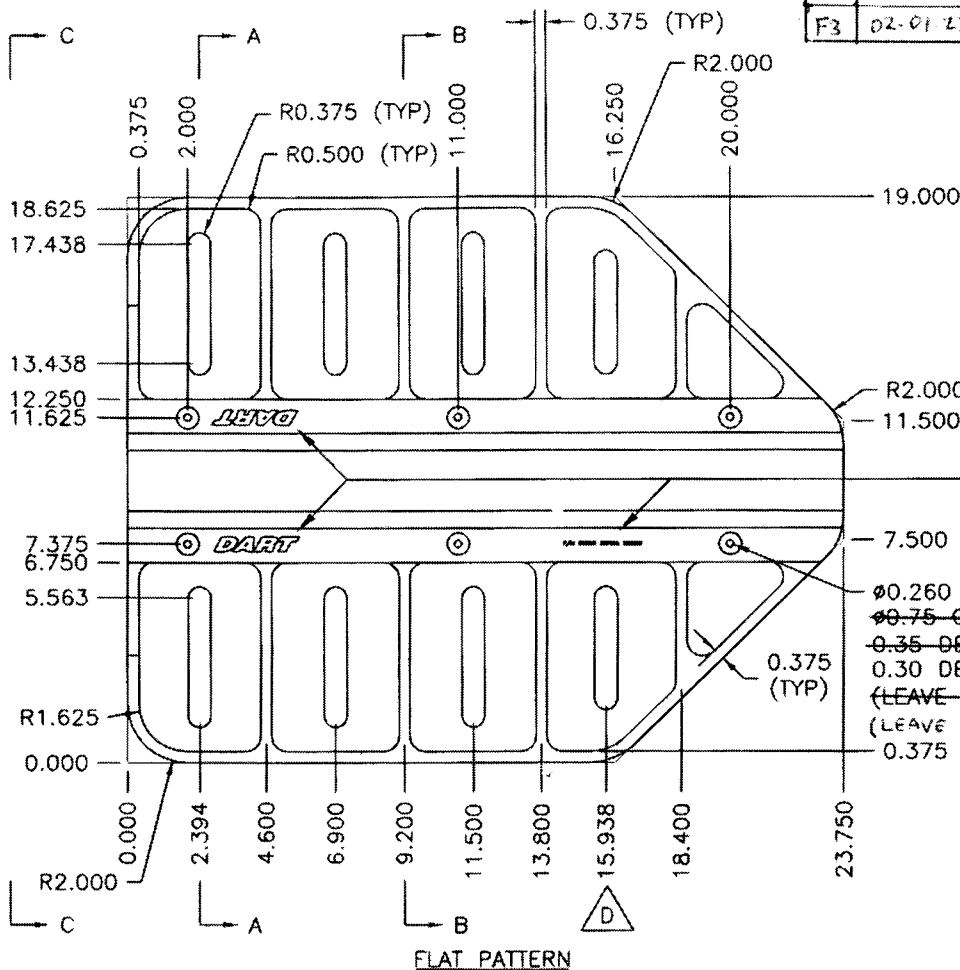
RELEASED  
99.06.17 KE

DART



807433  
ML  
1404/28

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



FL  
FI  
F

EFFECTIVE  
9143  
DECOS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED KE	
DATE 98.05.12	TITLE BEARPAW	REV. F SHEET 1 OF 2 SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

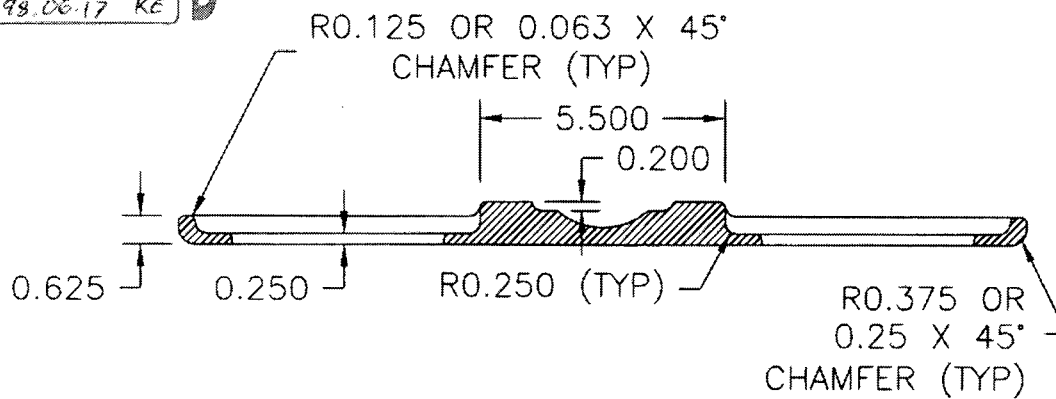
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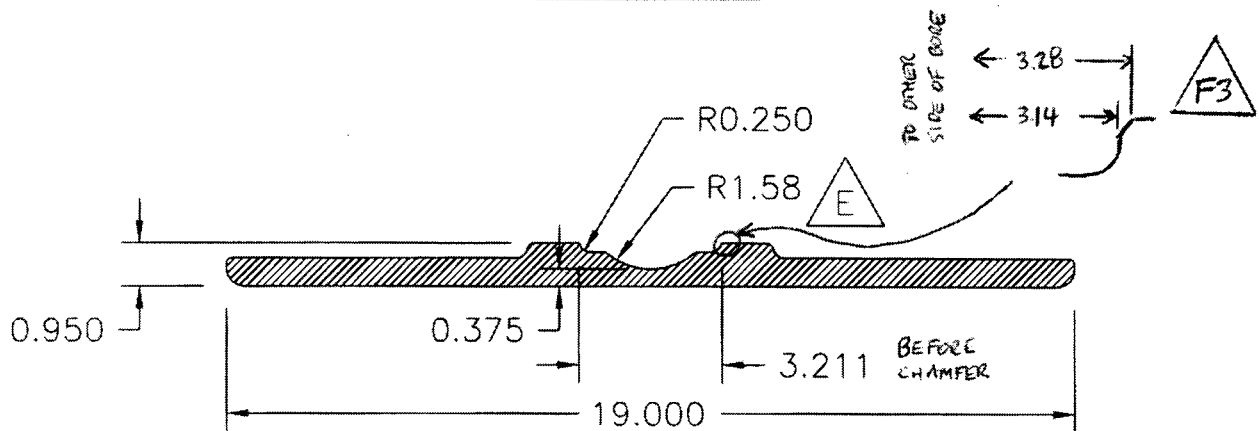


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

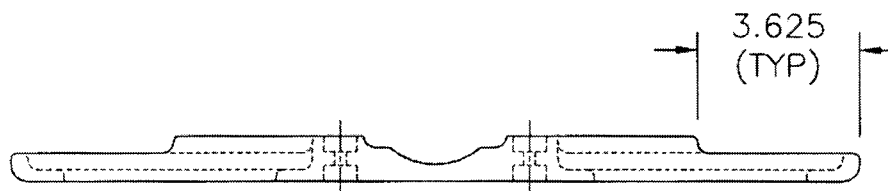
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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